

Work Order ID 69431

Wednesday, May 11, 2011 9:55:41 AM



Page 1

Item ID: D4398-1

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 5/11/2011 Start Qty: 20.00



Cust Item ID:

ASAP

Required Date: 5/13/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4398	A								

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

turn as per dwg and folio FB053

FOLIO REV: 2/4

DWG REV: A

DEBURR

SA 11/6/18

20 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 11/6/18

20 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 5/11/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

Re 11.6.8

20 4

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

11/6/2 SP (70)

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/6/9 JF

MF
11-06-08

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, May 11, 2011 9:55:36 AM

Page 1

Work Order ID: 69431



Parent Item: D4398-1



Parent Item Name: Bushing

Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: ipp revA 11.05.03 New issue ec verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R0.625

Purchased

No

100

f

14.5800

0.08

1.684211



11/6/18

303 Round Bar 0.625"

Location

Loc Qty

Loc Code

MAT028

14.58

110167

12.08

15267

2.5

1.684

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

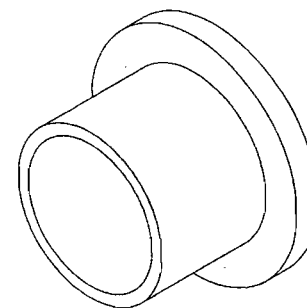
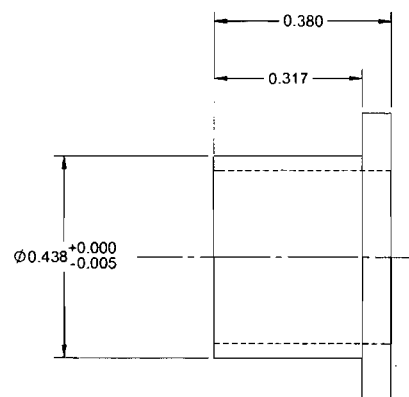
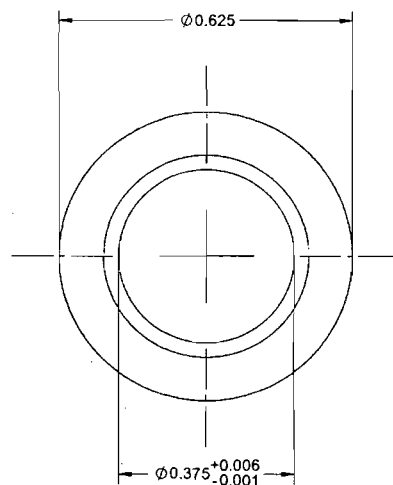
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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



#69431

D4398-1 BUSHING, ELECTRIC STEP

RELEASED
2011-05-11

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF. DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE	AJS	11.05.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4398	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BUSHING, ELECTRIC STEP	NTS
DATE	11.05.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPLICIT CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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